

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011518**Date Inspected:** 13-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Zhu zhong hai		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No
Weld Procedures Followed:	Yes	No
Verified Joint Fit-up:	Yes	No
Approved WPS:	Yes	No
Delayed / Cancelled:	Yes	No

Component: OBG Components

Bridge No: 34-0006**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

SMAW welding of weld joint 4G-005 located on PCMK SEG3004A of 12AW welder is identified as 045246. ZPMC QC is identified as Mr.Wang xu . The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-B-U2-FCM-1.

SAW welding of weld joint 1G-017 located on PCMK SEG3004AL of 12AW welder is identified as 045270. ZPMC QC is identified as Mr. Wang xu. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2C-S-2.

FCAW welding of weld joint 3G-049 located on PCMK DP106-001 of 11DW welder is identified as 202122. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-TC-U4b-F.

FCAW welding of weld joint 3F-066 located on PCMK CA3009L of 12BW welder is identified as 201215.ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-4133-2.

FCAW welding of weld joint 1G-010 located on PCMK 10TR3-105 welder is identified as 058551.ZPMC QC is

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

identified as Mr. Geng wei. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-TC-U4b-F.

BAY#19

FCAW welding of weld joint 2G-031 located on PCMK SB007-038 welder is identified as 062763.ZPMC QC is identified as Mr. Cheng zheng. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-TC-U4b-F.

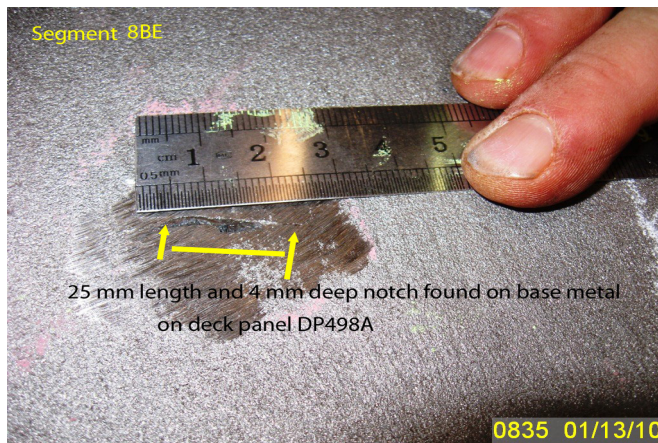
BLAST SHOP

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG segment 8BE External side panel, bottom panel surfaces from the panel point 65 to 67 after grit blasting. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel and areas those required additional welding marked, duct taped and recorded for future repair. The repair locations

Is identified as Base metal of DP498A near weld SEG046*-009. 4mm deep and 25mm length notch.

Weld no SEG046*-007 , straightening found 8 mm between DP444A and DP471A for 2m length continuously and informed to CT dimensional personnel.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Chadra

Quality Assurance Inspector

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Reviewed By: Patterson,Rodney

QA Reviewer